

Date: Tuesday, 19/08/2008 4:04:01 PM  
User: Julie Lecocq

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CLAMP
Job Number : 41430	
Estimate Number : 10600	
P.O. Number :	Part Number : D2519
This Issue : 19/08/2008 S.O. No. :	Drawing Number : D2519 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : PURCHASED PARTS	Drawing Revision : D
Previous Run : 34306	Material :
Written By :	Due Date : 30/09/2008 Qty: 50 Um: Each
Checked & Approved By : <u>NO 08-8-19</u>	
Comment : Est: B 00.03.16 Re-format, laser cutting EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 7002 C208/08/21

Laser cut as per Dwg D2519

Material release note required

(50)

2.0	D2519F	Clamp
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)  
Clamp

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

AS 08/09/16 (x50)

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK  
(8.561" center to center)

S 08/09/16 (x50) counter

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1  
1-Deburr any rough edges after tumbling  
2-Bend as per Dwg D2519

AS 08/10/10 (51)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 19/08/2008 4:04:01 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 41430

Part Number: D2519

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC5

INSPECT WORK TO CURRENT STEP



(P5)

Comment: INSPECT WORK TO CURRENT STEP

508/10/10 (51) counter

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble

8-10-9

(51)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 476

8-10-10 (51)

9.0

QC21

FINAL INSPECTION W/O RELEASE



08/10/14

Comment: FINAL INSPECTION W/O RELEASE

Job Completion



MF 08-10-10

Dart Aerospace Ltd

W/O: 41430		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
8/1/18	60 70	change operation at step 6. and step 7. Tanker should be enfont of respect a/c. PERMANENT CHANGE ESTIMATE: 10600	JA	08/10/14			8/1/18

Part No: D2519 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

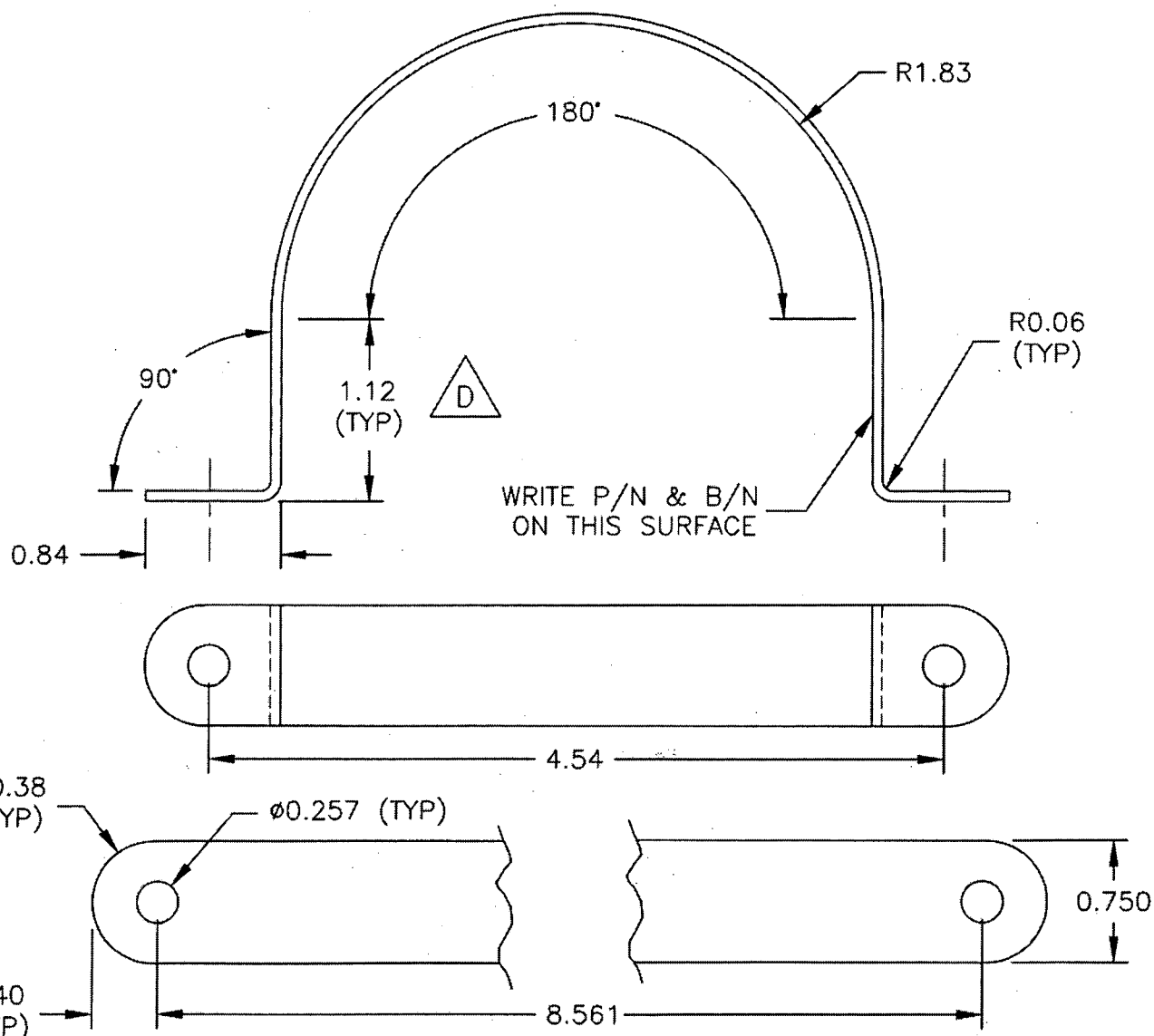
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN [Signature]	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2519	REV. D SHEET 1 OF 1
DATE 04.11.08		TITLE CLAMP	SCALE 1:1
A	95.11.28	NEW ISSUE	
B	97.03.24	ADD MATERIAL SPECIFICATION	
C	00.02.29	REDRAWN; ADDED FLAT PATTERN	
D	04.11.08	1.12 WAS 0.93	

RELEASED  
04.11.26 [Signature]



**NOTES:**

- 1) MATERIAL: AISI 304/316 SS 0.063 (16 GAUGE) THICK, (REF. DART SPEC. M304S16GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSION ARE IN INCHES
- 4) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT INK MARKER ON SURFACE SHOWN

**D2519 FLAT PATTERN**



180 AVENUE LABROSSE  
POINTE-CLAIRE, QUÉ., CANADA H9R 1A1  
TÉL.: (514) 630-4877 - FAX: (514) 630-4849

GFI est une division de Thomas & Betts Fabrication Inc. / GFI is a division of Thomas & Betts Manufacturing Inc.

PRODUIT À / SOLD TO



# BON DE LIVRAISON - SHIPPING MEMO

DATE DE LIVRAISON SHIPPING DATE	N° BON DE LIVRAISON SHIPPING MEMO NO.
2008/09/11	0402538

EXPÉDIÉ À / SHIPPED TO

DART AEROSPACE LTD  
1270 ABERDEEN ST.  
HAWKESBURY, ON, K6A 1K7

DART AEROSPACE LTD  
1270 ABERDEEN ST.  
HAWKESBURY, ON, K6A 1K7

CODE DE CLIENT CUSTOMER CODE		N° DE CONTRAT JOB NO.	N° COMMANDE PO NO.	VIA SHIP? VIA
DART GFI-0299		J0189517	PO00007002	
QUANTITÉ QUANTITY	VOTRE N° DE PIÈCE YOUR PART NO.		DESCRIPTION	
50	D2519F  ✓  8/12/2008  J  18 08/09/16		CLAMP	

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RECEPTION  
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.

# CERTIFICATE OF COMPLIANCE CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE  
POINTE CLAIRE, QC  
H9R 1A1

**DART AEROSPACE LTD**  
1270 ABERDEEN ST.  
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO. 3 OUR JOB NO. J0189517 SHIPPING MEMO 0402538

ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
<u>50 PCS</u>	<u>PO00007002</u>	<u>D2519F</u>	<u>D</u>	<u>CLAMP</u>	<u>D</u>	

MATERIAL

S.S.T 304

SUPPLIED BY

SAMUEL / AK STEEL

MAT. REL. NO.

7380365 ATT'D

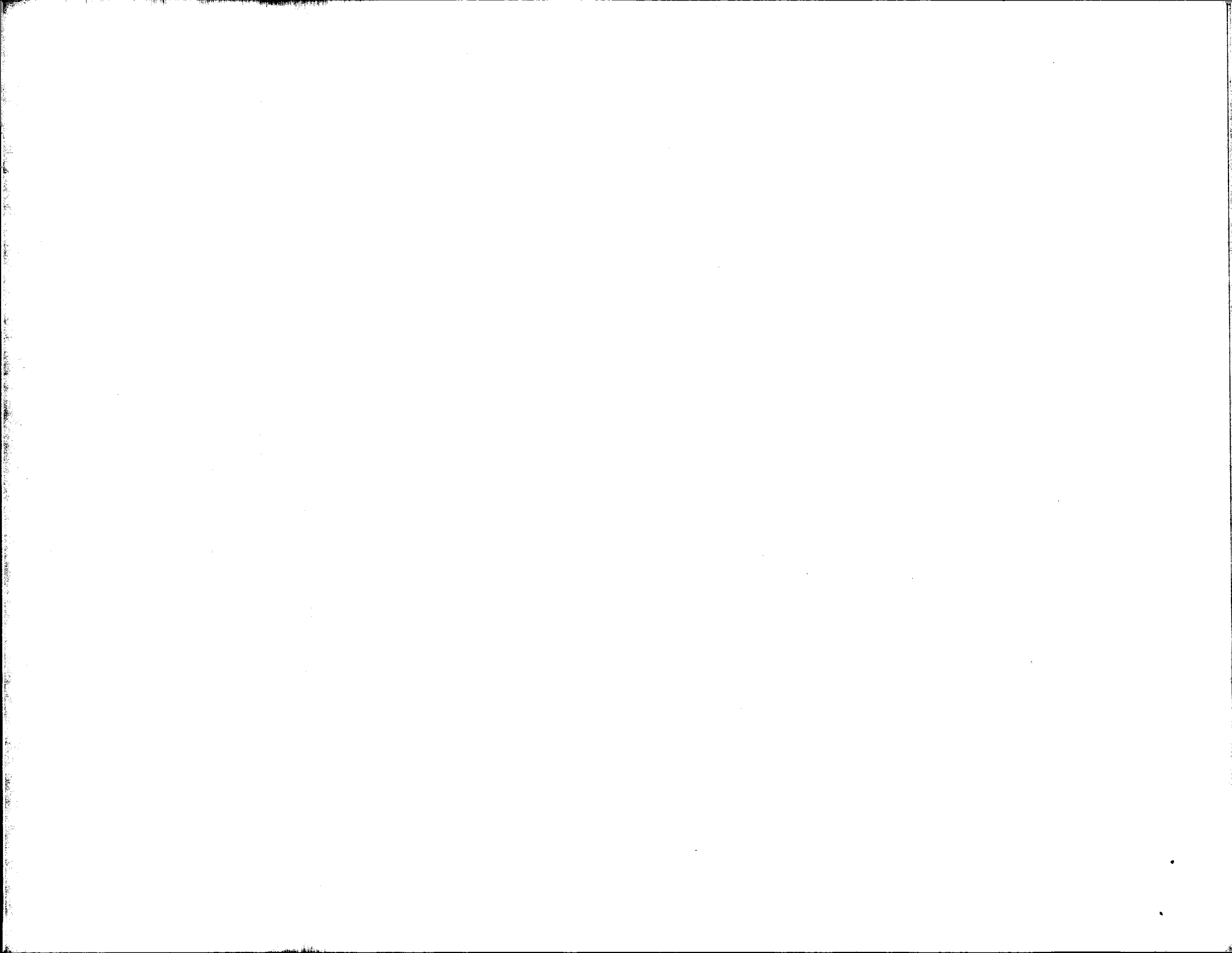
	PROCESS	PROCESSOR <i>02/09/18</i>	RELEASE NOTE #
1			
2			
3			
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 11 SEPTEMBER 2008

G.F.I. Q.C. REP. *Callan*









Programme d'Assurance Qualité Enregistré / Registered Q.A. Program  
ISO 9001:2000 AS9100

### LETTRE DE CONFORMITÉ --LETTER OF COMPLIANCE

Date: 3 SEPTEMBRE 2008

Company Name: G.F.I. Division of Thomas & Betts limited  
Address: 180 avenue Labrosse  
City: Pointe Claire, Qué.  
Zip Code: H9R 1A1

# du client: CC03584  
Customer's order #:

# de commande SSMQ: 883529  
SSMQ's Order #:

La présente est pour certifier que le matériel détaillé ci-dessous est conforme aux exigences de votre commande et des normes du grade tel que décrit:

The following is to certify that the material listed below meets your order requirements and grade standards as described:

Notre/Our Item #	# de pièces/ # of pieces	Épaisseur/Grandeur Guage/Size	Alliage/Trempe Alloy/Temper	Spécification / Specification	Lot/Heat
1	15	.060" X 48" X 96"	304 2B		7380365

Bien à vous,  
Yours truly,



*Muriel Giffiths*

Commis à l'administration.  
Administration Clerk.

LES MÉTAUX SPÉCIALISÉS SAMUEL, 21525 CLARK-GRAHAM, BAIE D'URFÉ, QUÉBEC H9X 3T5  
SAMUEL SPECIALITY METALS, 21525 CLARK-GRAHAM, BAIE D'URFÉ, QUÉBEC H9X 3T5

TÉL: 514-457-3399  
FAX: 514-457-9393

LET. DE COM 12/01/04



**AK Steel Corporation**  
**Metallurgical Test Report**  
**Rockport Works**  
**Rockport, IN 47635**

Page 1

Load No. 8970283  
 SRN No. 8970283

**CUSTOMER**  
 SAMUEL & FILS & CIE LTEE (S)  
 PUR DEPT  
 2225 FRANCIS HUGHES DRIVE  
 LAVAL, CN H7S1N 5

SHIP TO

SAMUEL & FILES (QUEBEC) LTEE  
 2225 FRANCIS HUGHES  
 LAVAL, CN H7S1N-5

MILL ORDER NO.  
 252502-1172  
 PART NO.

PROCESSOR ORDER NO.  
 C10360-3

BUYERS ORDER NO.  
 C10360-3

ENGLISH UNITS --PRODUCT-- METRIC UNITS  
 .0590 NOM 48.0000 X COIL

*See loc 1/2*

COIL ID	PIECE	HEAT	PARENT COIL ID	NET WEIGHT	OUTSIDE PROCESSOR ID
127733-01BAAB	1	7380365	0127733-01BAA	19,960 LBS. 9,054 KG.	466346802
TOTAL COILS	TOTAL PIECES			TOTAL NET WEIGHT	
1	1			19,960 LBS. 9,054 KG.	

L-Ladle Analysis of Heat

P-Product Analysis of Parent Coil

**CHEMICAL ANALYSIS**

ID	C	MN	P	S	SI	CR	NI	MO	N	CU						
L 7380365	.023	1.240	.025	.0026	.385	18.11	8.09	.29	.0330	.44						

SHIPPING DATE: 06/14/2008

REMARKS:

NO INTENTIONAL ADDITIONS OF MERCURY OR MERCURY COMPOUNDS WERE  
 MADE OR USED THROUGHOUT THE PROCESSING AND TESTING OF THIS MATERIAL.  
 MATERIAL FREE OF RADIOACTIVE ISOTOPES

**PRODUCT DESCRIPTION**

CR SHT TYPE 304/304L STAINLESS #2B FINISH SLIT EDGE TEST REPORTS. \* ASTM A 240 -07 \* ASTM A 480 -06 EX PARA 25.1.1.3 COIL WILL B  
 E TAGGED ON OUTSIDE ONLY \* ASME SA-240 SECTION II PART A (2004 ED, 2005 ADDENDA) \* ASME SA-480 SECTION II PART A (2004 ED, 2005  
 ADDENDA) \* ASTM A 262 -02A2 PRACTICE E \* ASTM A 666 -03 EX 7.1 TEST SPECIMENS WILL BE SELECTED IN THE TRANSVERSE TEST DIRECTION  
 IN ALL CASES.

PARENT COIL ID	POS (F/T)	DIR (L, T, D)	COND	% ELONG	TENSILE STRENGTH (KSI)	Y.S. .2% OFFSET (KSI)	ROCKWELL HARDNESS Tail	ROCKWELL HARDNESS Front			
0127733-01BAA	T	T	A.S.T.M	58.8	98.6	45.1	B 83	B 84			
PARENT COIL ID	POS (F/T)	DIR (L, T, D)	COND	ASTM A 262 PRACTICE E	BEND 180 IT						
0127733-01BAA	T		A.S.T.M	PASS	PASS						

THE CHEMICAL ANALYSIS AND PHYSICAL OR MECHANICAL TESTS REPORTED ABOVE ARE CORRECT  
 AS CONTAINED IN THE RECORDS OF THE CORPORATION.

ALL TESTING IS DONE IN ACCORDANCE WITH A.S.T.M. STANDARDS UNLESS OTHERWISE NOTED

AK Steel Corporation

MW/2/0004 5/00

SIGNATURE

"THIS CERTIFIED TEST REPORT HAS BEEN DELIVERED TO A CONSIGNEE OF MATERIAL PURCHASED FROM AK  
 Steel Corporation. TO AVOID THE POSSIBILITY OF MISUSE ON DELIVERY OF THE REPORT TO A  
 THIRD PARTY IT MUST BE RECERTIFIED BY AND UNDER THE NAME OF SUCH CONSIGNEE"

RYAN MARTIN QUALITY MANAGER

DATE 06/15/2008 TIME 05:37 AM